

Work Order ID 71958

Thursday, July 14, 2011 10:29:39 AM



Page 1

Item ID: D350-589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly LH

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mk

Date:

11-07-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2991

E

IIN-D350-589

E

100



DC

Document Control

DOCUMENT CONTROL

10

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D350-589-041

CHG006

*Schultz**RT 11-06-02*

103



Small Fab

Small Fab

Memo

0.00

0.00

1- Trim edge of door to fit moc up helicopter and touch up with primer and paint if necessary

RT 11-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				①	②	11-08-02	
110 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00				6A	RT	11-08-23	
140 	Small Fab	0.00							
Small Fab Small Fab	Memo	0.00							
	Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg								

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

✓ 11 08 24 (1)

160 Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP

(1X) 3P 11-08-26

170 QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subs/10

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Item Name: Side Door Assembly LH

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Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
	Memo	0.00							
	Packaging	Identify and pack for shipping as per PPP D350-589-041 Location: <u>S</u> PPP rev: _____							
190 	QC21- Final Inspection - Work Order Release	0.00							
	QC	Memo							
	Quality Control								

11/8/26

11/8/29


MF

11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 10:29:30 AM

Page 2

Work Order ID: 71958

Parent Item: D350-589-041

Parent Item Name: Side Door Assembly LH

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

110

Each

98.0000

3

3



Door Latch



85 11-08-23

Location

Loc Qty

Loc Code

ST204

98

64774

48

70557

50

X3

MS27039-1-15

Purchased No

110

Each

57.0000

3

3



Screw



85 11-08-23

Location

Loc Qty

Loc Code

ST292

57

116916

32

118093

25

X3

D2464-1700

Manufactured No

110

Each

0.0000

1

1



Neoprene Seal

61878



85 11-08-24

D3085-041

Manufactured No

110

Each

2.0000

1

1



prop ass'y



85 11-08-23

Location

Loc Qty

Loc Code

ST271

2

57545

2

X1

D2585

Manufactured No

110

Each

75.0000

3

3



Mounting Channel



85 11-08-23

Location

Loc Qty

Loc Code

ST017

75

69536

19

70814

56

X3

Thursday, July 14, 2011 10:29:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, July 14, 2011 10:29:30 AM

Page 3

Work Order ID: 71958

Parent Item: D350-589-041

Parent Item Name: Side Door Assembly LH

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,666.000

3

3



Nut



ST 11-08-23

Location

Loc Qty

Loc Code

ST300

1666

116549

28

117441

800

117601

400

117885

438

X3

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

3

3



Washer

118077



ST 11-08-23

MS20470AD4-5

Purchased

No

160

Each

561.0000

6

6



Rivet, Universal Head



SP 11-08-26

Location

Loc Qty

Loc Code

ST319

561

116893

561

6X

AN3-4A

Purchased

No

160

Each

601.0000

6

6



Bolt



SP 11-08-26

Location

Loc Qty

Loc Code

ST350

601

104291

300

104625

300

114374

1

6X

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, July 14, 2011 10:29:31 AM

Page 4

Work Order ID: 71958

Parent Item: D350-589-041

Parent Item Name: Side Door Assembly LH

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2237

Manufactured No

160 Each

54.0000

3



Striker Plate



SP

SP 08-11-26

Location

Loc Qty

Loc Code

ST009

54

66139

16

70558

38

3x

D2589

Manufactured No

160 Each

88.0000

1



Keys, Key Chain, 350 Hinge



SP

SP 08-11-26

Location

Loc Qty

Loc Code

ST018

88

58194

88

3x

MS21042L3

Purchased No

160 Each

1,666.000

6



Nut



SP

SP 08-11-26

Location

Loc Qty

Loc Code

ST300

1666

116549

28

117441

800

117601

400

117885

438

6x

Thursday, July 14, 2011 10:29:32 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

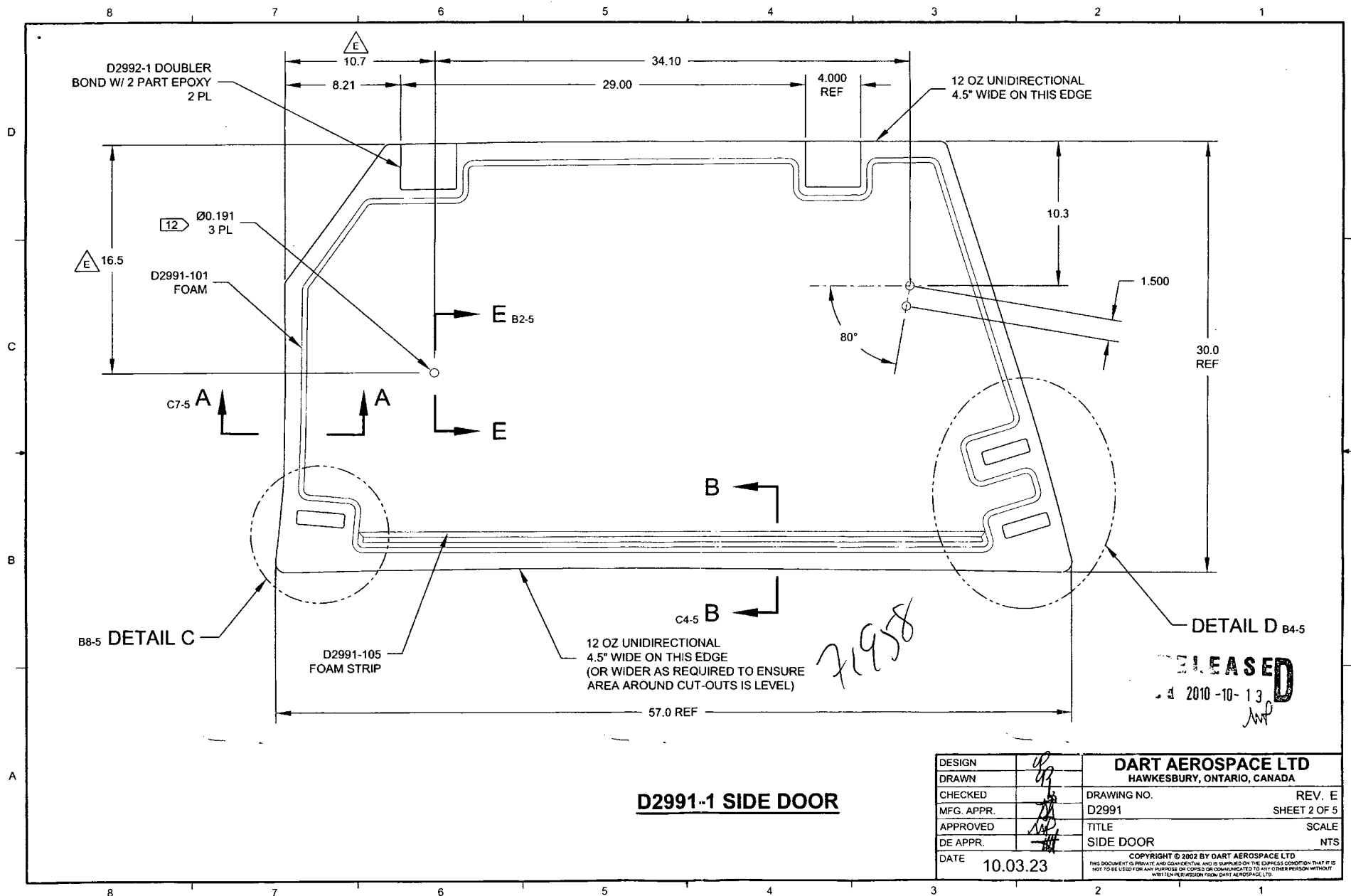
- 1) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 2) FINISH: FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9 lbs TYP
- 8) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 9) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 10) LAYUP PER QSI 006 AND AS FOLLOWS:

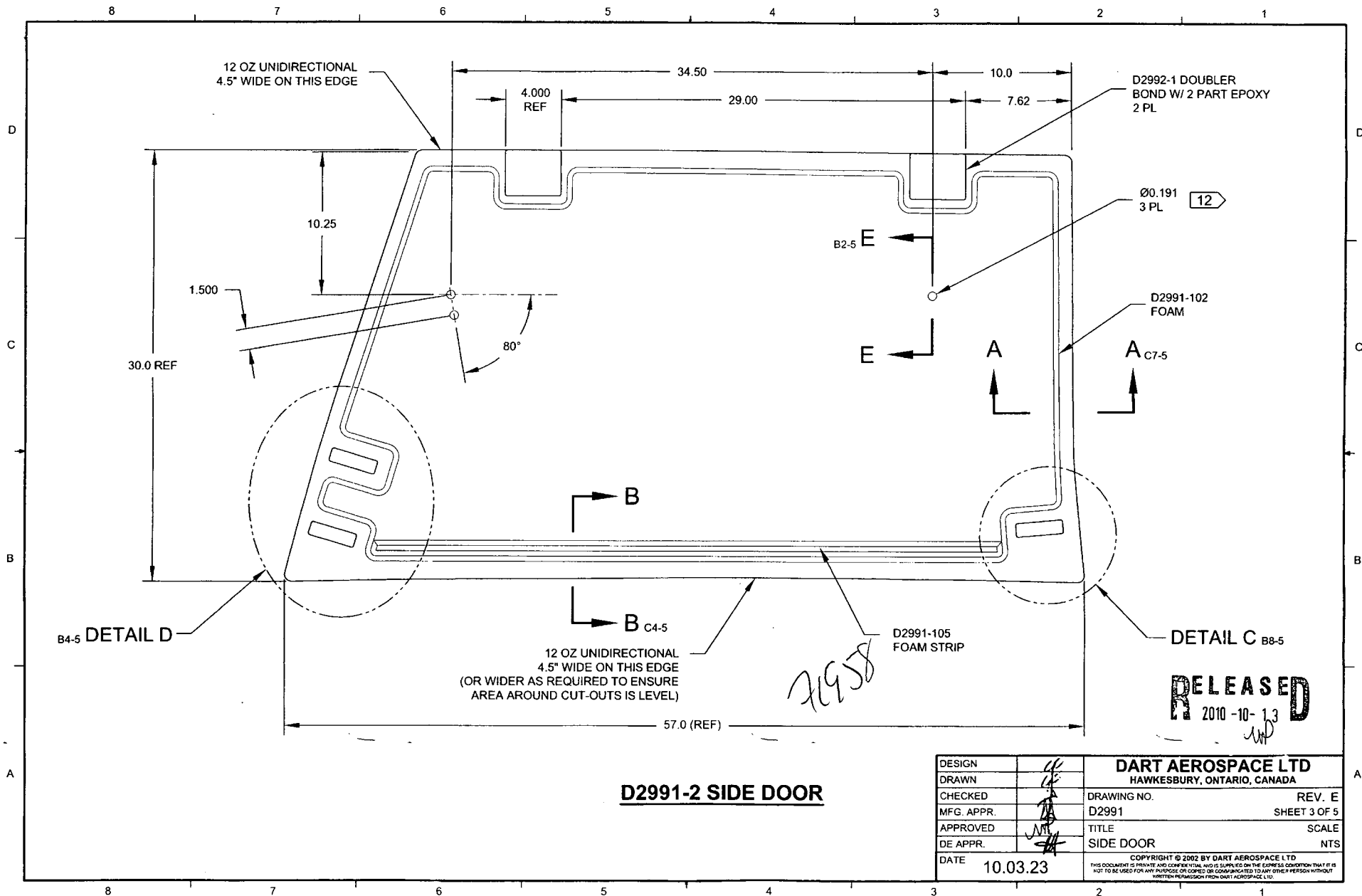
MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 11) BOND FOAM CORE USING POLYBOND B46F
- 12) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.

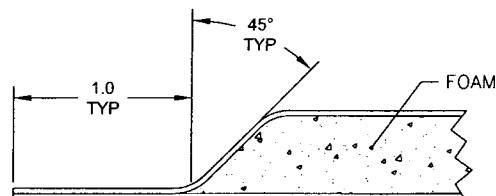
RELEASED
2010-10-13

E	REFORMAT, MOVE HOLE: 16.5 WAS 10.25 (ZN C8-2) 10.7 WAS 10.2 (ZN D7-2), PAR 10-007	CP	10.03.23
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.23		

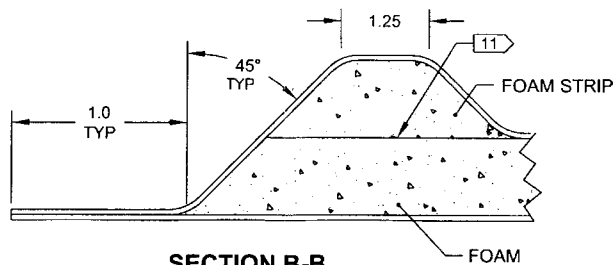
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. E SHEET 1 OF 5
TITLE SIDE DOOR	SCALE N
COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT MAY NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



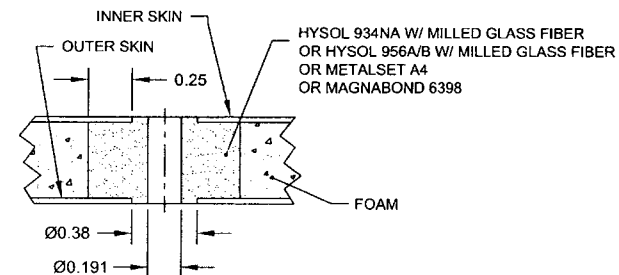




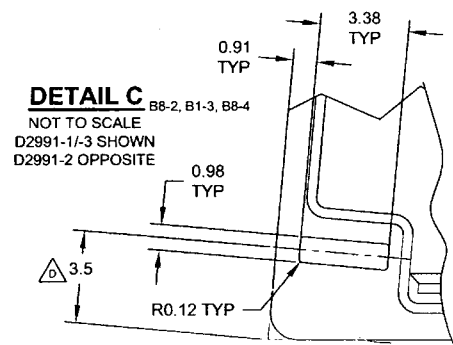
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



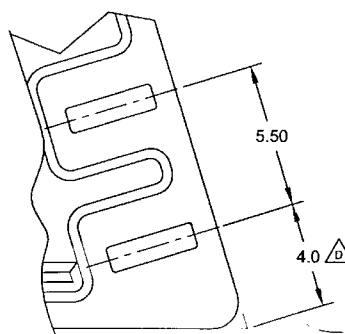
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



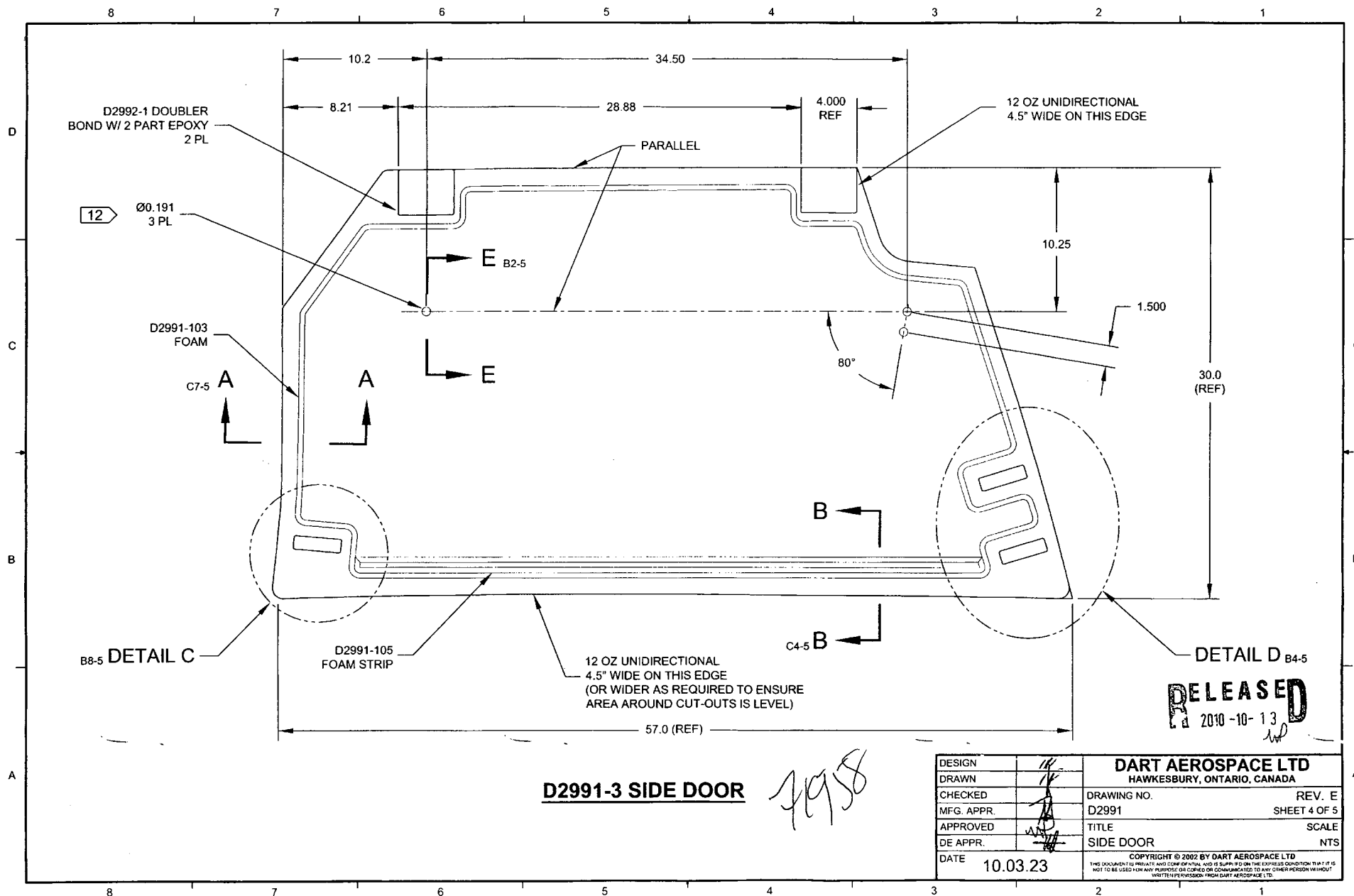
DETAIL C B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE

RELEASED
2010-10-13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	10.03.23	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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REFERENCE ONLY**52.4 PARTS LIST**

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate ✓
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3) -3
6	6	6	6	MS20470AD4-5	Rivet ✓
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x Ø0.129 (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 09.02.03
CERT. NO.: SH92-41
ISSUE NO.: 7

A	NEW ISSUE	<u>[Signature]</u>	09.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>[Signature]</u>	DART AEROSPACE LTD	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9446	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	SWITCH RELOCATION	NTS
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REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x Ø0.129 (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes Ø0.179 x 100° from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.04
CERT. NO.: SH92-41
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MFG. APPR.	N/A	DSI 9447	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ADJUSTMENT	NTS
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